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D5189-041
Job Sheet 190077



Part No: D5189-041

Job Qty: 4 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 2/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG-REV A IPP-REV:A 14.11.27 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	2/25/19		0.00	4.43	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	2/25/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	2/25/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
130 Powdercoat - 3 Grey Sand - B4B	4 pcs	2/25/19	0.00 0.12		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-02-11
					Powdercoat - 4 - B4B	
140 QC 3	4 pcs	2/25/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	DAS 40 9-55 9-55
					QC 3 - 9	
150 Packaging 3-1 - Stock - B4B	4 pcs	2/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 -	

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					B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	STR23 MAR 06 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	4 pcs	2/25/19	0.00	0.00	QC 21 - SA - 21	DAS MAR 06 2019
					QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part Op 100 - (Fabricate per Drwg), 1-Cut tube as per Dwg D5189 2-Drill tube as per Dwg D5189 using DT8622 3-Debur 4-Weld
 Descriptions: stud and end cap as per Dwg D3021 QSI004 A/R 4130 Rod Batch: 127925

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 START TIME: 11.45 OVEN TEMPERATURE: 520°

FINISH TIME: 12.15 m 138439

140 - QC3- Inspect Part Finish

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

Job BOM

008000

Part / Item	Component Name	Quantity	Operation	Container
D3017-11	Cap	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	105203
D4667-041	Armrest Stud Assembly	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	65443
M4130NT0.750W.049	4130 Round Tube .750 X.049W	8.5280 ft (2.132 ea)	100-Large Fab - Welded Assy-1	92701

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3017-11	4	43	0
	D4667-041	4	6	0
	M4130NT0.750W.049	9	30	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S152036



Part: D5189-041

Job No: 190077

Serial No/Batch: S152036

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/08/19